

Work Order ID 103901

July-04-13 7:39:33 AM

103901

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Item ID: 646.9702 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cutter Sub Assembly (U Channel)
 Start Date: 7/04/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 7/04/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
646.9700	A

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces per note .								
	A/R RTV LOCTITE 598: 125306								
	exp. date: 12/14								

130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

② 13.07.04

② 13.07.04

2 DAS 05 13.07.04

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Item ID: 646.9702 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cutter Sub Assembly (U Channel)
Start Date: 7/04/13 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 7/04/13 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

② 130701

13/7/4 ②

MF
13-7-4

Picklist Print

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Work Order ID: 103901

Parent Item: 646.9702

Parent Item Name: Cutter Sub Assembly (U Channel)

Start Date: 7/04/13

Required Date: 7/04/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE JFS 13/07/03 VERIFY BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
601.1541 LOCKNUT(MS21042L08) (8-32 THD) (CAD PLATED) (100 Q		Purchased	No			110	Each	0.0000	6	12			
601.2764 WASHER (NAS1149FN832P)		Purchased	No			110	Each	0.0000	12	24			
646.9711 Blade		Manufactured	No			110	Each	185.0000	2	4			

Location

Loc Qty

Loc Code

ST139E
90824
ST437
91807
ST537
98911
st543
100268

4
4
2
2
81
81
98
98

B 130704

646.9712
Body
MS27039-08-19
Screw

Manufactured No
Purchased No

110 Each 0.0000 1 2
110 Each 2,257.0000 6 12

B103260
M125654 B 130704

Location

Loc Qty

Loc Code

ST307
123525
ST309
125654
st510
124309

89
89
968
968
1200
1200

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03912

SHEET 1

DWG NO. 646.9700

REV: N/C

PREPARED BY:

J. BECKER

DATE: 06/06/13

EFFECT

☒ INC. ☐ U.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: ADDED NOTE 9, ADDED SHEET 6, INCORPORATED
ECN'S 02744 AND 03838.

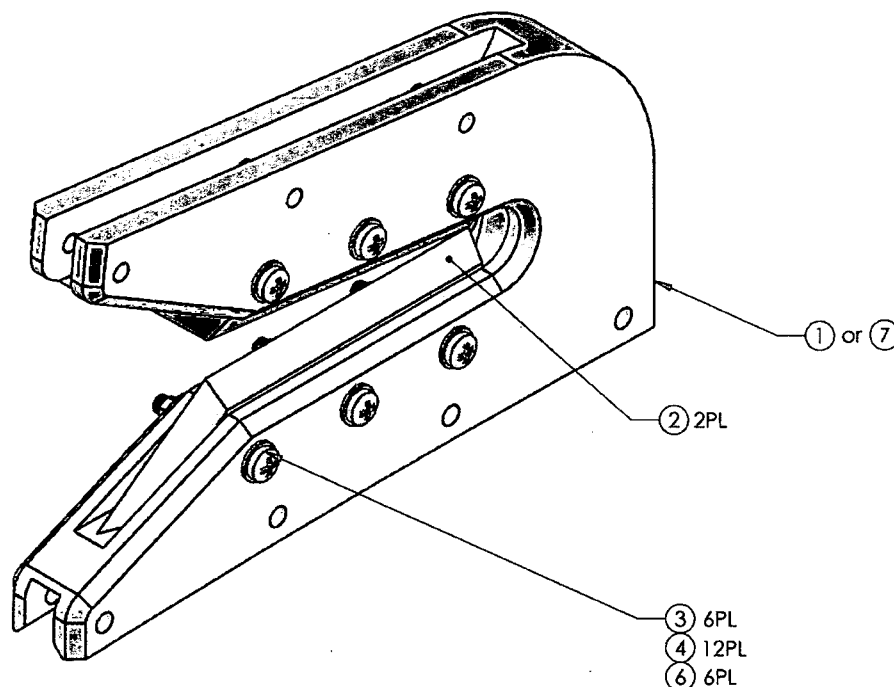
7	C	646.9712	1		BODY (U CHANNEL)	1	2 9
	C	646.9702	<input checked="" type="checkbox"/>		CUTTER SUB ASSY (U CHANNEL)		
F/N	TC	PART NUMBER	.9702	.9701	DESCRIPTION	MATERIAL	SPECIFICATION
			QTY				
DOCUMENTS EFFECTED:					CHANGE CATEGORY	DER REVIEW REQUIRED	
					<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM	<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

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





REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
REV.	LAST PROTOTYPE REVISION: P12		N/C
N/C	INITIAL RELEASE	05/29/07	P. BRAVO
A	INCORPORATED ECH 027 AL 03035 03P12	04/04/13	P. BRAVO

NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.



646.9701
or
646.9702

	1		7	646.9712	BODY (U CHANNEL)		
	6	6	6	601.1541	LOCKNUT	MS21042R08	
	A/R	A/R	5	601.2764	RIV, LOCTITE 598		
	12	12	4	601.2764	WASHER	MS1149H833P	
	6	6	3	601.2765	SCREW	MS27035-0819	
	2	2	2	646.9711	BLADE		
		1	1	646.9710	BODY		
				646.9702	CUTTER SUB ASSY (U CHANNEL)		
				646.9701	CUTTER SUB ASSY		
9702	9701	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.	
QTY				PARTS LIST			
NEXT ASSY (S)				APICAL INDUSTRIES			
646.9600				2608 TEMPLE HEIGHTS DR.			
646.9700				OCEANSIDE, CA. 92056-3512 (760)724-5300			
				CUTTER SUB ASSY			
				JALTS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°			
				REV. 8 CAGE CODE 07M26 DWG NO. 646.9700			
				SCALE NONE SHEET 1 OF 6			